


ASAP











Date: Tuesday, 4/3/2007 12:39:56 PM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 31573		
Estimate Number	: 10384		
P.O. Number	: <i>N/A</i>	Part Number	: D3195043
This Issue	: 4/3/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3195 REV A
First Issue	: //	Project Number	: N/A
Previous Run	: 27841	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/10/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20
Comment	: Est Rev A New Issue 05-11-08 JLM	Um:	Each





Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
		
Comment: Qty.: 0.3150 f(s)/Unit Total : 6.3000 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.250x1.500) Identify for D3195-3 Batch: <i>M6061</i> <i>07-04-05</i>		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blanks: (1.250" x 1.500") x 3.60" long <i>07-04-05</i> (20)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3 2-Deburr <i>07-04-05</i> (20)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>07-04-05</i> 20		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>07-04-05</i> 20		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/18	3.0	Three parts machined with 1/4 RSD not 3/16 RSD. operator (ED) pulled wrong end mill. changed end mill to proper.		Parts have been re-worked and are within tolerance 07.04.05	En 07/04/18	 07/04/18	 07.04.05	 07/04/18

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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20X

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-A

07/04/09

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

FL

07/04/10

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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20X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A

07/04/11

9.0	D31957	Pad
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3195-7	PAD	031611

M-A 07-04-17

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Lightly Sand bonding surface

2-Bond D3195-7 into D3195-13as per Dwg D3195
A/RContact Cement M102565

M-A 07-04-17 (20)

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07-04-17 (20)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

07-04-17 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/3/2007 12:39:56 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31573

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



00

Comment: FINAL INSPECTION/W/O RELEASE

2007/04/18

Job Completion



U 87-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

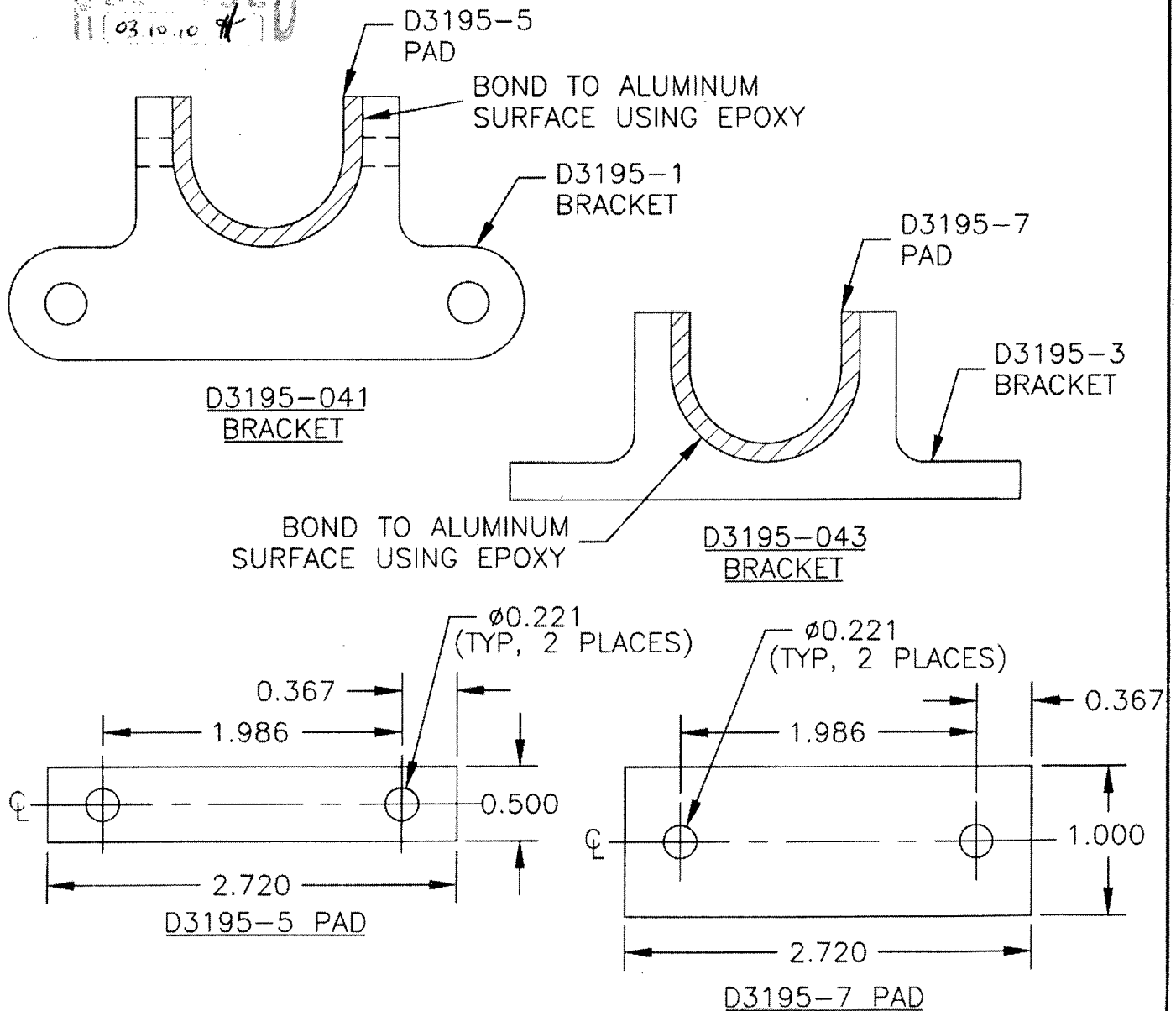
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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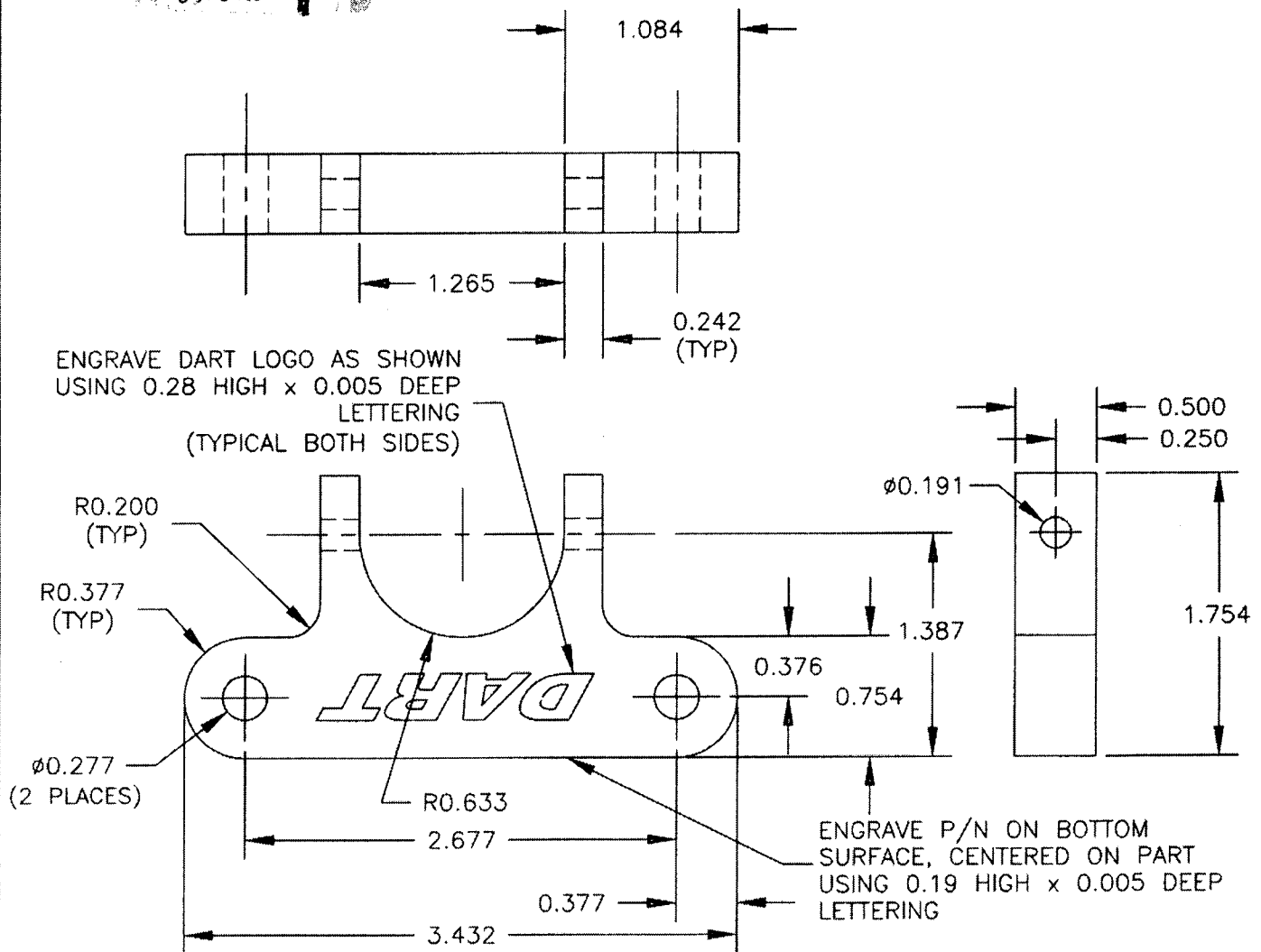
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0207104103
w/o 31573



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

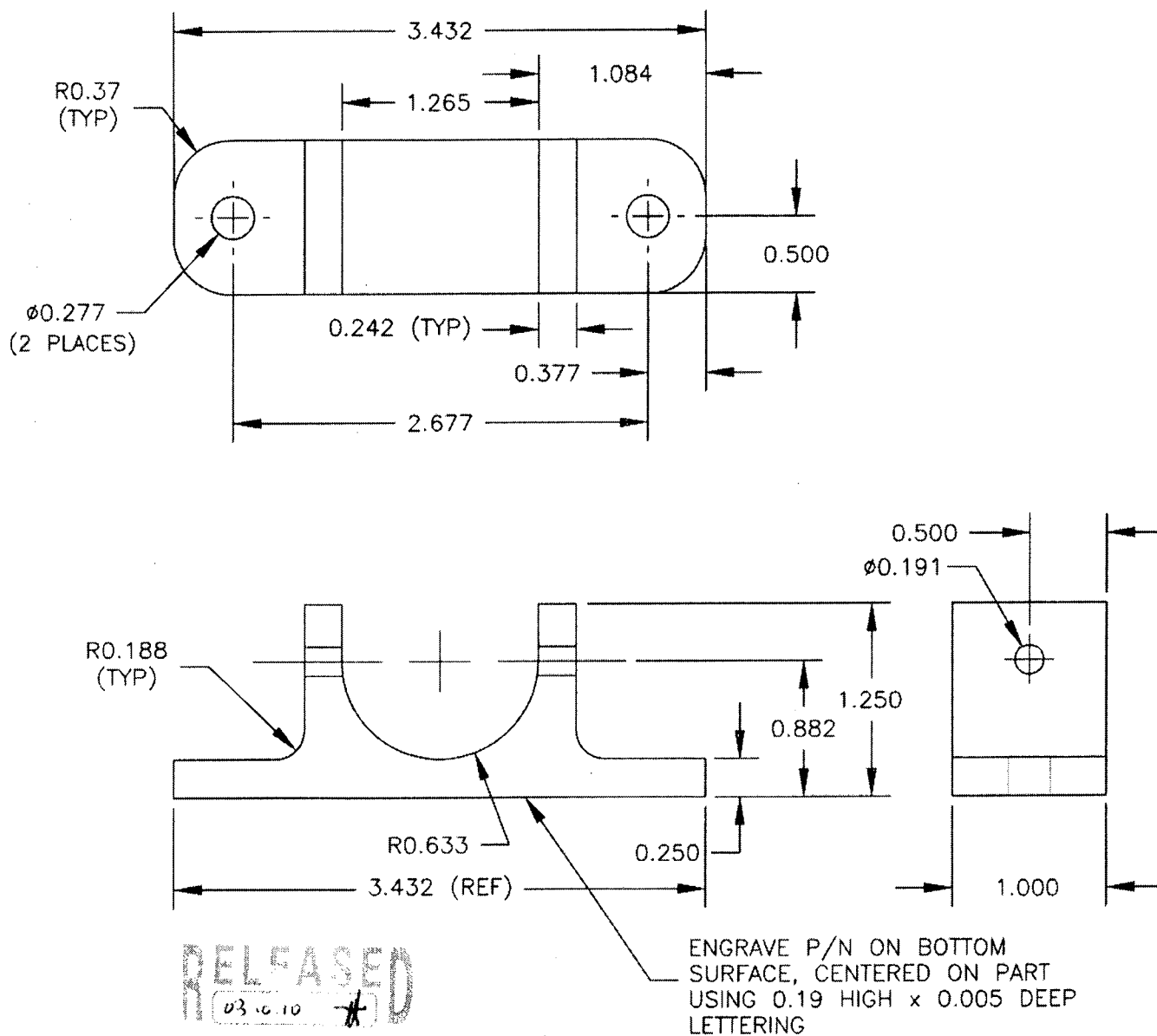
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CJ07/04/03
W/0 31573



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
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0207104103
W/O 31573

DART AEROSPACE LTD		Work Order: 31573
Description: Bracket		Part Number: D3145-3
Inspection Dwg: D31453 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	± 0.010	3.433	✓			
1.265	± 0.010	1.261	✓			
1.144	±0.010					
0.500	± 0.010	0.496	✓			
0.377	± 0.010	0.373	✓			
0.242	± 0.010	0.242	✓			
2.677	± 0.010	2.675	✓			
Ø 0.277	$\begin{matrix} +0.005 \\ -0.001 \end{matrix}$	0.281	✓			
R 0.37	± 0.030	0.375	✓		R-4	
R 0.188	± 0.010	.188	✓			
1.250	± 0.010	1.247	✓			
0.882	± 0.010	0.876	✓			
0.250	± 0.010	0.245	✓			
3.4						
0.500	± 0.010	0.497	✓			
Ø 0.191	$\begin{matrix} +0.005 \\ -0.001 \end{matrix}$	0.193	✓			
1.000	± 0.010	1.001	✓			

Measured by: En	Audited by: <i>RL</i>	Prototype Approval:
Date: 07/04/05	Date: 07-04-05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	